DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026765
Date Inspected: 29-Nov-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	As noted below.			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Component

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

West Line

This QA observed, at random intervals, ABF/JV qualified welder Salvador Sandoval #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1004-R. This welding was performed to repair a base metal crack previously discovered by Quality Control personnel using the Magnetic Particle Testing (MT) method. This work was located at 14W-PP128-W3-LLH#2 and was performed in the flat position from the top of the “A” deck plate.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=136).

This QA observed QC Pat Swain perform Magnetic Particle (MT) of the excavated weld at various increments of depth.

Final excavation measurements were recorded to be:

(D=25mm, L=170mm, W=25mm)

This repair was performed on a Seismic Performance Critical Member (SPCM) member.

This QA observed, at random intervals, ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal

Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1004-R. The joint being welded was a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 14W-PP128-W4-LLH#4 and was performed in the flat position from the top of the "A" deck plate.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded as (A=136).

This welding was performed to repair a QCUT reject.

Approximately 8:00 this QA observed QC Salvador Moreno perform Magnetic Particle (MT) of the excavated weld at this panel point 14W-PP128-W4-LLH#4 location. Mr. Moreno recorded no rejectable indications at this time.

Excavation measurements were recorded to be:
(Y=286mm, D=13mm, L=85mm, W=30mm)

This joint is a Seismic Performance Critical Member (SPCM) member.

This QA observed, at random intervals, ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1004-R. The joint being welded was a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 14W-PP128-W4-LLH#3 and was performed in the overhead position from the bottom of the "A" deck plate.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded as (A=131).

This welding was performed to repair a QCUT reject.

Approximately 11:10 this QA observed QC Salvador Moreno perform Magnetic Particle (MT) of the excavated weld at this panel point 14W-PP128-W4-LLH#3 location. Mr. Moreno recorded no rejectable indications at this time.

Excavation measurements were recorded to be:
(Y=580mm, D=10mm, L=110mm, W=30mm)

This joint is a Seismic Performance Critical Member (SPCM) member.

Observation of QCUT:

QC Pat Swain performed Ultrasonic Testing (UT) of the completed weld at:
14E-PP126.7-E2.9 -no recordable or rejectable indications.

Please see QCUT reports dated 11/29/11 for more information regarding these indications.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer